

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009676**Date Inspected:** 07-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #11 East and West Tower Shop

East tower lift 3:- Caltrans QA inspector observed ten ZPMC welders performed FCAW process on CJP welds of corner diagonal stiffener plates of skin plates C to D and B to C. The locations of corner diagonal stiffener plates are from 82.25m to 111.67m. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

West Tower Lift #3:- Caltrans QA Inspector observed six ZPMC grinders in process of grinding on fit lugs of interior diaphragms. The fit lugs located at the elevation 85.25m to 111.67m diaphragm sections that connected skin plate D of west tower lift #3. The grinding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were

West Tower Lift #3:- Caltrans QA Inspector observed two welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate B to C of west tower lift #3. The FCAW repair welding located at elevation 82.5m and 99m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #4:- Caltrans QA Inspector observed seven ZPMC workers and three welders in process fit up and SMAW tack welding on skin plate E of east tower lift 4. A numerous temporary tack welds have been welded

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attach to the skin plate E to A after secured by temporary supports. Base on Caltrans QAI observation, no discrepancies were noted.

Tower Assemble Yard

East Tower Lift #2:- Caltrans QA Inspector observed six ZPMC workers in process holes drilling on two interior connection plates which connect to skin plate D. The interior connection plates have been secured by few bolts and clamps prior drilling. The holes drilling process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

South Tower Lift #1:- Caltrans QA Inspector observed six ZPMC workers performed drilling process on three strut connection areas for the skin plate C of south tower lift #1. The holes template has been removed after holes has been marked and secured. The holes drilling process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinoved 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
